

## ABSTRACT

An axial intermediate portion of raw material is held with a holding die in a state in which the intermediate portion is prevented from being enlarged in diameter. The axial end portions of the raw material is inserted in forming dented portions formed at axial end portions of the holding die. The scheduled diameter-enlarging portions are inserted in insertion passages formed in guides. Then, the scheduled diameter-enlarging portions are simultaneously pressed with punches to fill the material of the scheduled diameter-enlarging portions in corresponding forming dented portion while moving each guide in a direction opposite to a moving direction of each punch, thereby enlarging each scheduled diameter-enlarging portion.